

Shp ASAP Ezof

-1  
-3

Work Order ID 71526

Wednesday, July 06, 2011 11:08:25 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4331-041

Revision ID: PRELIM

Item Name: Doubler Assembly

Start Date: 7/6/2011 Start Qty: 1.00

Required Date: 7/7/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *W*

Date:

QC:

Date:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Tooling:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4331

PA1 *PA6*

100

Pick Kit

0.00

Packaging

Memo

0.00

*SB 11/08/08*

Packaging

110

0.00

Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG

*SB 11/08/08*

*(1)*

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

*- inspected to PA6  
Dry only  
8/10/08*

# Work Order ID 71526

Wednesday, July 06, 2011 11:08:25 AM

Page 2

Item ID: D4331-041  
Revision ID: PRELIM  
Item Name: Doubler Assembly

Accept

Setup Start

Stop

Start Date: 7/6/2011 Start Qty: 1.00  
Required Date: 7/7/2011 Req'd Qty: 1.00

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

R02334

ME 11-08-09

POSITIVE RECALL  
EFFECTIVE 11-07-06 AUTH W  
RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

# Picklist Print

Wednesday, July 06, 2011 11:08:23 AM

Page 1

Work Order ID: 71526

Parent Item: D4331-041

Parent Item Name: Doubler Assembly



Start Date: 7/6/2011

Required Date: 7/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-07-05 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4331-1 		Manufactured	No				Each	0.0000		1	72632	8/11/08	
Doubler D4331-3 		Manufactured	No				Each	0.0000		1	71530	8/11/08	
Angle MS20470AD4-3 		Purchased	No				Each	6,007.000		9	1118405	8/11/08	
Rivet - Universal Head													

## Location

MEZZ

1642

2193

## Loc Qty

6007

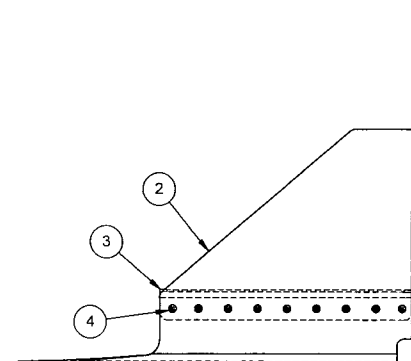
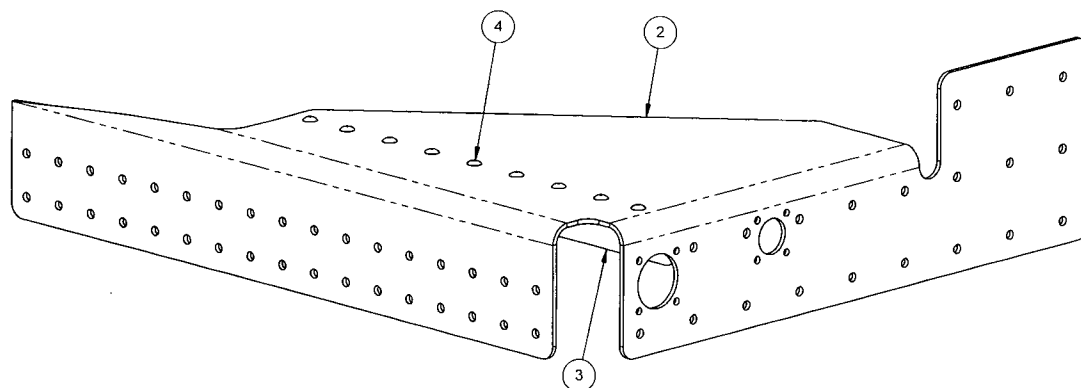
1373

4634

## Loc Code

7

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4331-041	DOUBLER ASSEMBLY
2	1	D4331-1	DOUBLER
3	1	D4331-3	ANGLE
4	9	MS20470AD45	RIVET



**D4331-041 DOUBLER ASSEMBLY**

w/o 21526

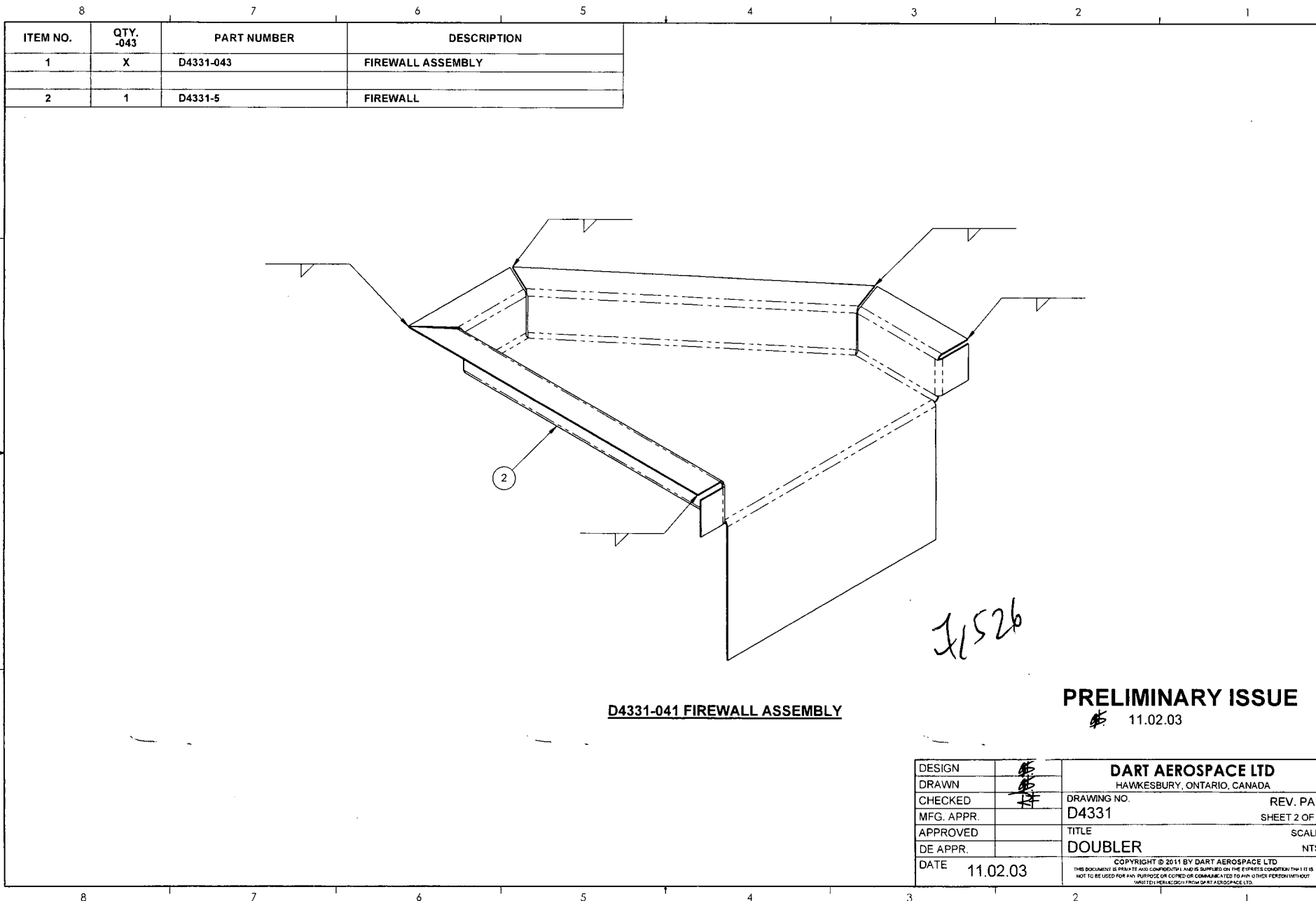
NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1  
 7) WEIGHT: 0.34 lbs

**PRELIMINARY ISSUE**

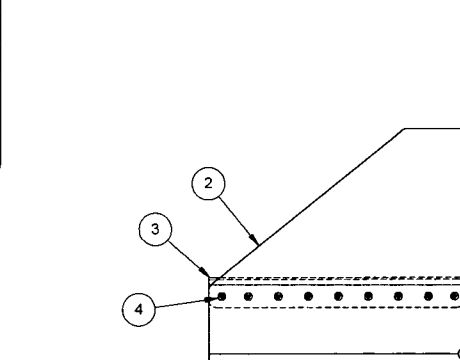
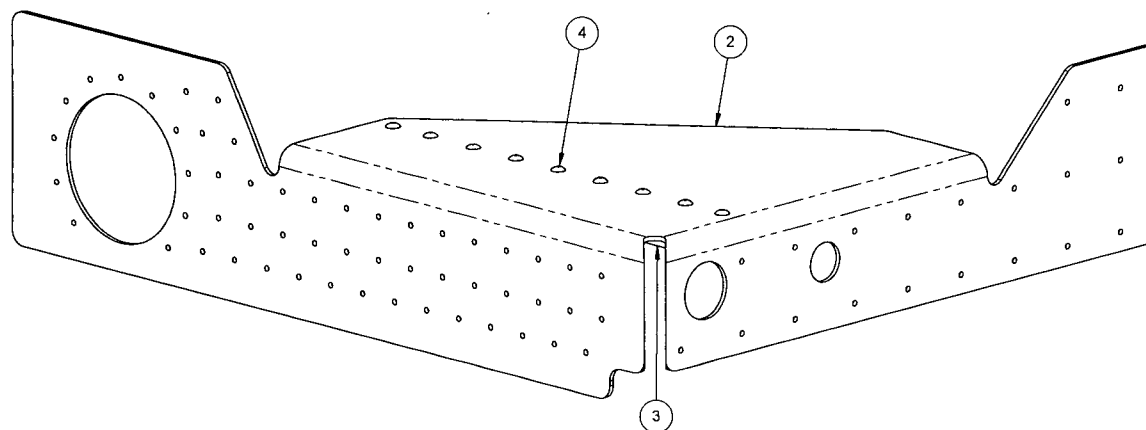
11.02.03

PA1	NEW ISSUE	11.02.03
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	11.02.03	

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4331</b>	REV. PA1 SHEET 1 OF 8
TITLE <b>DOUBLER</b>	SCALE NTS
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1.	X	D4331-041	DOUBLER ASSEMBLY
2	1	D4331-1	DOUBLER
3	1	D4331-3	ANGLE
4	9	MS20470AD4-3	RIVET



**D4331-041 DOUBLER ASSEMBLY**

**PRELIMINARY ISSUE**

11.02.03

NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1  
 7) WEIGHT: 0.38 lbs

PA6	NEW ISSUE		11.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.03		

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 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4331** REV. PA6  
 SHEET 1 OF 9

TITLE **DOUBLER** SCALE  
 NTS

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## Melanie Fauteux

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**From:** Harvey Siemens <hsiemens@dartaero.com>  
**Sent:** Tuesday, August 09, 2011 10:23 AM  
**To:** 'Melanie Fauteux'  
**Subject:** D4331

Melanie

It is permissible to use the MS20470AD4-5 rivets in place of the drawing specified MS20470AD4-3 rivets.

Regards,

*Harvey Siemens*

Mechanical Designer  
DART Aerospace Ltd.

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